

ASAP

Dart Aerospace Ltd.

Date: Friday, 04/04/2008 9:46:50 AM  
 User: Julie Lecocq

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	INNER FWD SADDLE
<b>Job Number</b> :	38366		
<b>Estimate Number</b> :	11079		
<b>P.O. Number</b> :		<b>Part Number</b> :	D5953
<b>This Issue</b> :	04/04/2008	<b>Drawing Number</b> :	D5953 REVB
<b>Prsht Rev.</b> :	NC	<b>Project Number</b> :	N/A
<b>First Issue</b> :	04/04/2008	<b>Drawing Revision</b> :	B
<b>Previous Run</b> :	36460	<b>Material</b> :	
<b>Written By</b> :		<b>Due Date</b> :	23/04/2008
<b>Checked &amp; Approved By</b> :	<u>JD 08.4.4</u>	<b>Qty:</b>	20 Um: Each
<b>Comment</b> :	Est Rev:E Re-Format 05-11-29 JLM Est Rev:f ecn 826 06.12.06 EC		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6101007	7075-T7351 8.25X7.75X2.5
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 16.0000 Each(s)  
 D6101-007(7075-T7351)  
 Size 2.50" x 7.50" X 8.25" (Grain along 7.50")  
 Batch: 13 31389

2.0	HAAS3	HAAS CNC VERTICAL MACHINING #3
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**Comment:** HAAS CNC VERTICAL MACHINING #3

1-Machine as per folio D5953, Ensure Batch Number is entered

2-Machine Keyway

3-Deburr & Tumble

3.0	QC1	INSPECT ALL DIM TO DIM SHEET
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**Comment:** INSPECT ALL DIM TO DIM SHEET

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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**Comment:** HAND FINISHING RESOURCE #1  
 Chemical Conversion Coat as per QSI 005 4.1

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Friday, 04/04/2008 9:46:50 AM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: INNER FWD SADDLE

Job Number: 38366

Part Number: D5953

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	POWDER COATING	POWDER COATING
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Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M 107550

BL 08-04-22

30 min  
22/04/2008

S.093 14.38

#1 319.6

#3 D.5953

#3 38366

7.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-04-22

(X20)

8.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

12 4/23 (20)

9.0	QC21	FINAL INSPECTION/W/O RELEASE
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08/04/24

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF

08-04-23

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 38366
<b>Description:</b> Inner Fwd Saddle		<b>Part Number:</b> D5953
<b>Inspection Dwg:</b> D5953	<b>Rev:</b> B	<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443		.442	.442	.442	.442		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	5.245	5.255		5.250	5.250	5.250	5.250		
D	6.995	7.005		7.002	7.000	7.000	7.000		
E	5.245	5.255		5.250	5.250	5.250	5.250		
F	4.745	4.755		4.750	4.750	4.750	4.750		
G	0.315	0.322		.319	.319	.319	.319		
H	1.522	1.532		1.526	1.526	1.526	1.526		
I	3.048	3.058		3.050	3.050	3.050	3.050		
J	4.575	4.585		4.580	4.580	4.580	4.580		
K	0.313	0.318		.318	.318	.318	.318		
L	0.495	0.505		.501	.501	.501	.501		
M	0.490	0.510		.503	.502	.503	.502		
N	1.615	1.635		1.625	1.625	1.625	1.625		
O	7.990	8.010		8.000	8.003	8.003	8.002		
P	2.240	2.260		2.250	2.250	2.250	2.250		
Q	0.307	0.312		.312	.312	.310	.312		
R	0.760	0.765		.762	.762	.762	.762		
S	0.490	0.510		.501	.500	.502	.500		
T	1.375	1.395		1.380	1.381	1.381	1.381		
U	2.000	2.020		2.000	2.002	2.002	2.002		
V									
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: JF
Date: 08/04/16

Audited by: EC
Date: 08.04.18

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
B	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686 & DT8696 A/B	KJ/RF	
C	06.12.06	Dimensions L,N,P revised	KJ/EC	
D	07.06.15	Dimension G revised	KJ/JLM	

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 38366
<b>Description:</b> Inner Fwd Saddle		<b>Part Number:</b> D5953
<b>Inspection Dwg:</b> D5953		<b>Rev:</b> B
		<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	5 1	6 2	7 3	8 4	By	Date
A	0.438	0.443		.443	.443	0.443	0.443		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	5.245	5.255		5.250	5.250	5.250	5.250		
D	6.995	7.005		7.000	7.000	7.000	7.000		
E	5.245	5.255		5.250	5.250	5.250	5.250		
F	4.745	4.755		4.750	4.750	4.750	4.750		
G	0.315	0.322		.319	.319	.319	.319		
H	1.522	1.532		1.526	1.526	1.526	1.526		
I	3.048	3.058		3.051	3.051	3.051	3.051		
J	4.575	4.585		4.580	4.580	4.580	4.580		
K	0.313	0.318		.318	.318	.318	.318		
L	0.495	0.505		.501	.502	.502	.502		
M	0.490	0.510		.503	.503	.503	.503		
N	1.615	1.635		1.635	1.635	1.635	1.635		
O	7.990	8.010		8.000	8.000	8.000	8.000		
P	2.240	2.260		2.250	2.250	2.250	2.250		
Q	0.307	0.312		0.312	0.311	0.310	0.310		
R	0.760	0.765		0.760	0.760	0.760	0.760		
S	0.490	0.510		.501	0.5085	0.505	0.508		
T	1.375	1.395		1.385	1.388	1.388	1.3845		
U	2.000	2.020		2.007	2.002	2.002	2.002		
V									
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: <u>25</u>	<u>DSP</u>
Date: <u>08/04/16</u>	<u>08/04/17</u>

Audited by: <u>EC</u>
Date: <u>08.04.18</u>

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
B	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686 & DT8696 A/B	KJ/RF	
C	06.12.06	Dimensions L,N,P revised	KJ/EC	
D	07.06.15	Dimension G revised	KJ/JLM	

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 38366
<b>Description:</b> Inner Fwd Saddle		<b>Part Number:</b> D5953
<b>Inspection Dwg:</b> D5953	<b>Rev:</b> B	<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				9	10	11	12		
A	0.438	0.443		.443	.443	0.443	0.443		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	5.245	5.255		5.250	5.250	5.250	5.250		
D	6.995	7.005		7.000	7.000	7.000	7.000		
E	5.245	5.255		5.250	5.250	5.250	5.250		
F	4.745	4.755		4.750	4.750	4.750	4.750		
G	0.315	0.322		.319	0.321	0.321	0.321		
H	1.522	1.532		1.526	1.527	1.527	1.526		
I	3.048	3.058		3.050	3.053	3.052	3.053		
J	4.575	4.585		4.580	4.580	4.580	4.580		
K	0.313	0.318		.318	0.318	0.318	0.318		
L	0.495	0.505		.501	0.500	0.500	0.500		
M	0.490	0.510		.503	0.502	0.502	0.502		
N	1.615	1.635		1.629	1.629	1.629	1.627		
O	7.990	8.010		8.000	8.000	8.000	8.002		
P	2.240	2.260		2.250	2.250	2.250	2.250		
Q	0.307	0.312		0.311	0.311	0.311	0.311		
R	0.760	0.765							
S	0.490	0.510		0.504	0.502	0.502	0.504		
T	1.375	1.395		1.385	1.385	1.385	1.386		
U	2.000	2.020		2.003	2.003	2.003	2.004		
V									
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: <i>RF</i>	<i>DJP</i>
Date: 05/04/16	03/04/17

Audited by: <i>RF</i>
Date: 05.04.17

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
B	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686 & DT8696 A/B	KJ/RF	
C	06.12.06	Dimensions L,N,P revised	KJ/EC	
D	07.06.15	Dimension G revised	KJ/JLM	

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 38366
<b>Description:</b> Inner Fwd Saddle		<b>Part Number:</b> D5953
<b>Inspection Dwg:</b> D5953	<b>Rev:</b> B	<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	13	14	15	16		
A	0.438	0.443		0.443	0.443	0.443	0.443		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	5.245	5.255		5.250	5.250	5.250	5.250		
D	6.995	7.005		7.000	7.000	7.000	7.000		
E	5.245	5.255		5.250	5.250	5.250	5.250		
F	4.745	4.755		4.750	4.750	4.750	4.750		
G	0.315	0.322		0.321	0.321	0.321	0.321		
H	1.522	1.532		1.527	1.526	1.527	1.526		
I	3.048	3.058		3.053	3.051	3.052	3.052		
J	4.575	4.585		4.580	4.580	4.580	4.580		
K	0.313	0.318		0.318	0.318	0.318	0.318		
L	0.495	0.505		0.500	0.500	0.500	0.500		
M	0.490	0.510		0.502	0.503	0.503	0.503		
N	1.615	1.635		1.628	1.628	1.628	1.627		
O	7.990	8.010		8.000	8.000	8.001	8.001		
P	2.240	2.260		2.250	2.250	2.250	2.250		
Q	0.307	0.312		0.311	0.311	0.311	0.311		
R	0.760	0.765							
S	0.490	0.510		0.496	0.492	0.499	0.498		
T	1.375	1.395		1.385	1.3863	1.3865	1.3855		
U	2.000	2.020		2.003	2.004	2.005	2.004		
V									
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: <u>DTP</u>
Date: <u>08/04/17</u>

Audited by: <u>RF</u>
Date: <u>08.04.18</u>

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
B	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686 & DT8696 A/B	KJ/RF	
C	06.12.06	Dimensions L,N,P revised	KJ/EC	
D	07.06.15	Dimension G revised	KJ/JLM	



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	
<b>Description: Inner Fwd Saddle</b>		<b>Part Number: D5953</b>	
<b>Inspection Dwg: D5953</b>		<b>Rev: B</b>	
		<b>Page 1 of 1</b>	

Inspect dimensions highlighted on inspection sheet drawing and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				17	18	19	20		
A	0.438	0.443		0.443	0.443	0.443	0.443		
B	1.745	1.755		1.748	1.748	1.749	1.750		
C	5.245	5.255		5.250	5.250	5.250	5.250		
D	6.995	7.005		7.002	7.001	7.003	7.000		
E	5.745	5.755		5.750	5.750	5.749	5.749		
F	4.745	4.755		4.749	4.749	4.748	4.749		
G	0.315	0.322		0.321	0.321	0.321	0.321		
H	1.522	1.532		1.528	1.528	1.529	1.527		
I	3.048	3.058		3.054	3.054	3.054	3.053		
J	4.575	4.585		4.580	4.580	4.580	4.580		
K	0.313	0.318		0.318	0.318	0.318	0.318		
L	0.495	0.505		0.500	0.500	0.500	0.500		
M	0.490	0.510		0.503	0.503	0.503	0.503		
N	1.615	1.635		1.627	1.627	1.630	1.630		
O	7.990	8.010		8.000	8.000	8.000			
P	2.240	2.260		2.250	2.250	2.250	2.250		
Q	0.307	0.312		0.311	0.310	0.310	0.310		
R	0.760	0.765		0.760	0.760	0.760	0.760		
S	0.490	0.510		0.496	0.500	0.506			
T	1.375	1.395		1.386	1.386	1.387	1.3805		
U	2.000	2.020		2.004	2.004	2.005	2.004		
V									
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

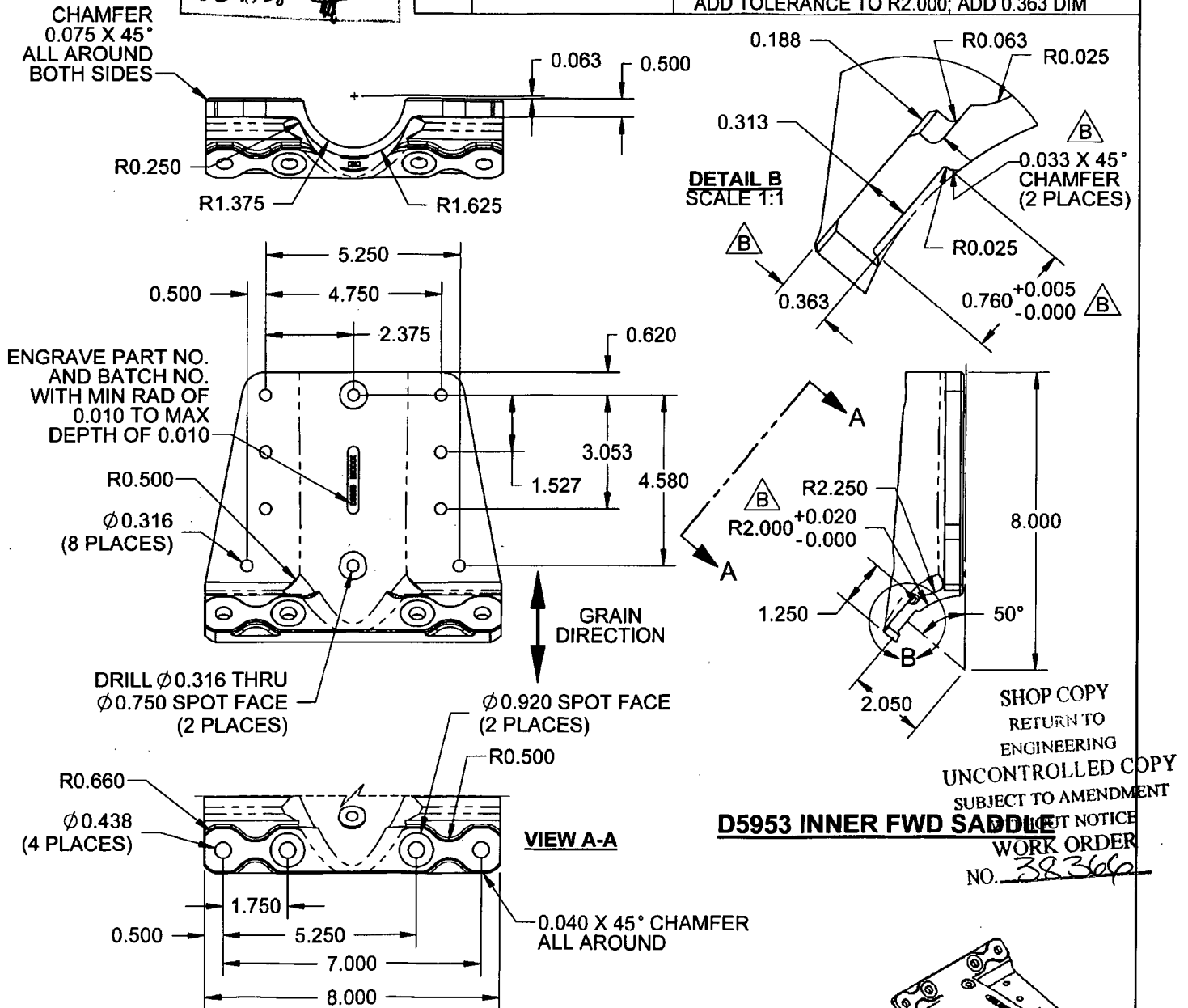
Measured by: <i>DJP</i>
Date: <i>08/04/18</i>

Audited by: <i>SB</i>
Date: <i>08.04.18</i>

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
B	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686 & DT8696 A/B	KJ/RF	
C	06.12.06	Dimensions L,N,P revised	KJ/EC	
D	07.06.15	Dimension G revised	KJ/JLM	<i>[Signature]</i>

**DART**

DESIGN <b>BW</b>	DRAWN BY <b>CB</b>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <b>LE</b>	APPROVED <b>#</b>	DRAWING NO. <b>D5953</b>	REV. B SHEET 1 OF 1
DATE <b>06.11.07</b>	TITLE <b>INNER FWD SADDLE</b>		SCALE 1:4
REV A	DATE 97.05.06	DESCRIPTION NEW ISSUE	
B	06.11.07	INCORPORATE DEO 9102, DEO 9079; ADD 0.363 DIMENSION; $\phi 0.316$ WAS $\phi 0.313$ ; ADD TOLERANCE TO R2.000; ADD 0.363 DIM	

**NOTES:**

- 1) MATERIAL: ALUMINUM 7075-T7351 PER QQ-A-250/12  
(MAKE FROM D6101-007 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.010 TO 0.020

**ISOMETRIC VIEW**  
SCALE 1:8

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